EFFECTIVITY
MODEL: 707/720
SSI DOCUMENT (D6-44860)
REFERENCE:
SSD 53-A00-17
SSD 53-A10-17
SSD 53-A20-17
SSD 53-A30-17
SSD 53-A40-17

PART 6 - EDDY CURRENT

FUSELAGE - FITTINGS

1. Purpose

   A. To detect surface cracks in the aluminum forward fin terminal fitting clevis hole and two adjacent fastener holes, BS 1440.

2. Equipment

   A. Instruments and reference standards per Part 6, 51-00-00, Fig. 1, Fastener Holes in Aluminum Parts.

   B. Bolt hole probes per Part 6, 51-00-00, Fig. 1, Fastener Holes in Aluminum Parts.

3. Preparation for Inspection

   A. Access - (Area is accessible from outside the body)

      (1) Remove fin.

      (2) Remove bushing from fin terminal fitting clevis hole.

      (3) Remove fasteners (2 places) as shown in Detail I.

   B. Clean loose dirt, paint, grease, etc. from inside and around clevis hole and fastener holes.

   C. Remove built-up paint, sealant, etc. from around outside of holes where probe will bear.

      NOTE: If surface of hole is extremely rough, a clean-up ream may be used.

4. Instrument Calibration

   A. Perform instrument calibration per Part 6, 51-00-00, Fig. 1, Fastener Holes in Aluminum Parts.

Forward Fin Terminal Fitting Clevis, BS 1440
Figure 1 (Sheet 1)

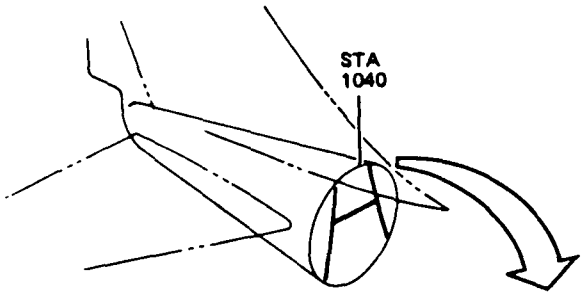
5. Inspection Procedure

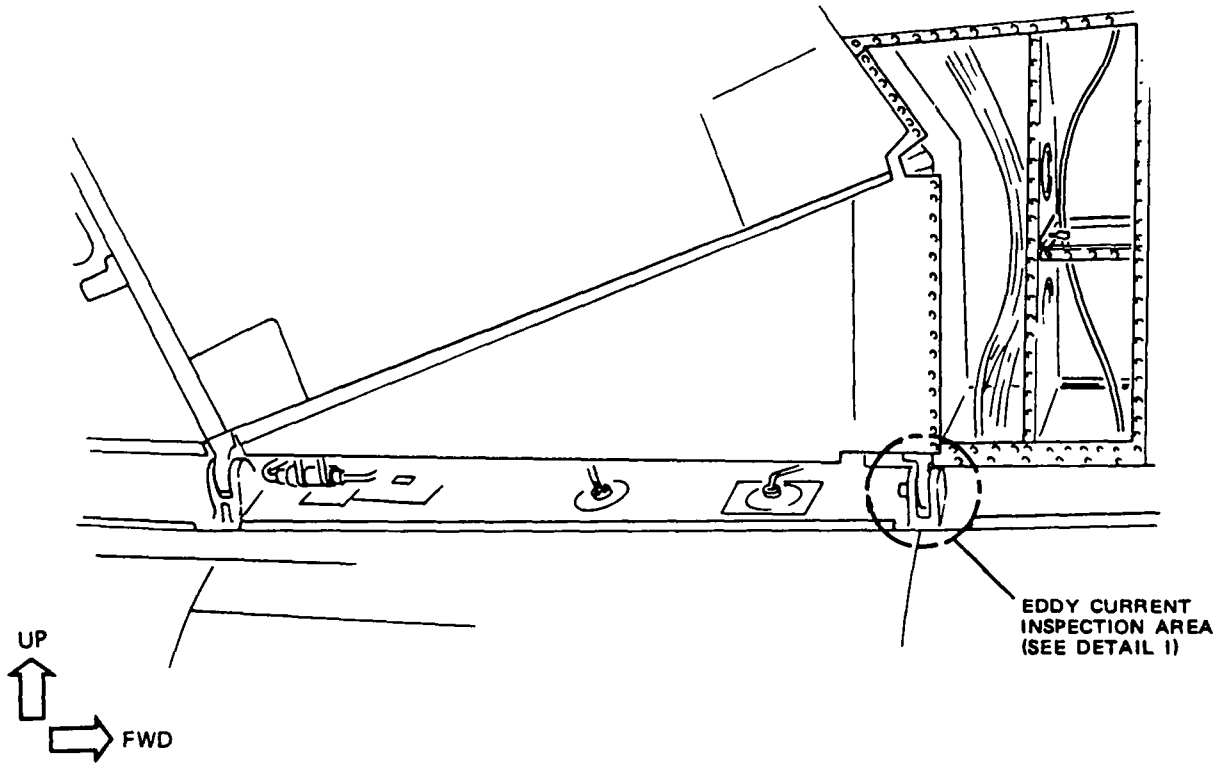
A. Perform inspection per Part 6, 51-00-00, Fig. 1, Fastener Holes in Aluminum Parts.

B. Inspect fastener holes 2 places, See Detail I.

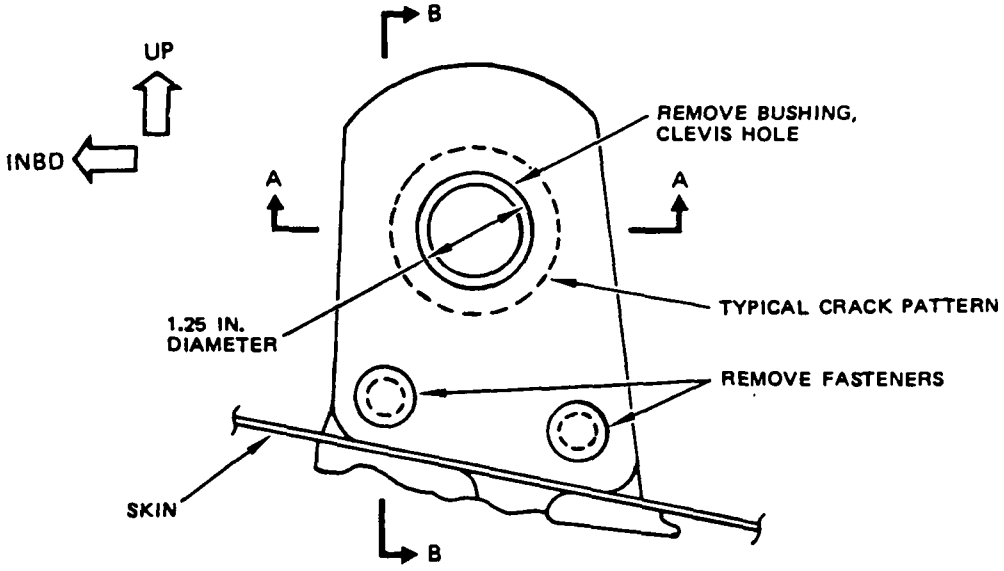
C. Inspect fin terminal fitting clevis hole.

Forward Fin Terminal Fitting Clevis, BS 1440
Figure 1 (Sheet 2)

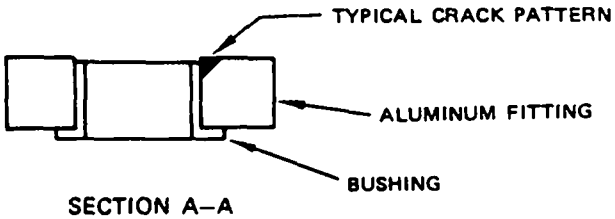




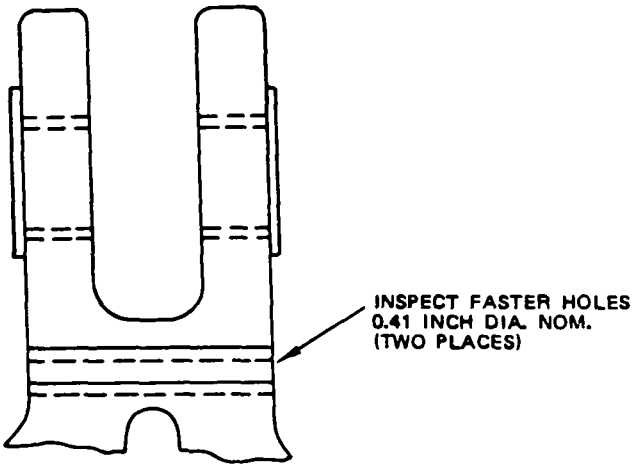
Forward Fin Terminal Fitting Clevis, BS 1440
Figure 1 (Sheet 2A)



EDDY CURRENT INSPECTION AREA
DETAIL 1



SECTION A–A



SECTION B–B

Forward Fin Terminal Fitting Clevis, BS 1440
Figure 1 (Sheet 3)

EFFECTIVITY
MODEL: 707/720
SERVICE BULLETIN REFERENCE: 2933 & 3216
SSI DOCUMENT (D6-44860) REFERENCE:
SSD 53-A05-11A
53-A05-11B
53-A15-11A
53-A15-11B
53-A25-11A
53-A35-11A
53-A35-11B
53-A45-11A
53-A45-11B
53-A45-11C
53-A45-11D

PART 6 - EDDY CURRENT

FUSELAGE - FITTINGS

1. Purpose

   A. To detect cracks in the steel aft fin terminal fitting attachment holes common to the fin terminal fitting and vertical flange of the BS 1505.87 bulkhead chord.

      NOTE: The fastener holes in the aft fin terminal fitting may also be inspected by means of a magnetic rubber inspection method. The use of magnetic rubber is described in Section 20-20-01 (Magnetic Particle Inspection) of the Overhaul Manual. The fastener holes should be inspected for cracks in the inboard or outboard direction.

2. Equipment

   A. Instrument and reference standards per Part 6, 51-00-00, Fig. 2, Fastener Holes in Steel Parts.

   B. Bolt hole probes per Part 1, 51-06-00, Fig. 1, Typical Eddy Current Probes and Part 6, 51-00-00, Fig. 1, Fastener Holes in Aluminum Plates.

3. Preparation for Inspection

   A. Gain access to BS 1505.87 bulkhead chord in the area of the aft fin terminal fittings per operator's standard procedure.

      NOTE: Access to the aft side of the fitting may be obtained by removing the internal access panels in the BS 1519 web.

Aft Fin Terminal Fitting Attachment Holes, BS 1505.87
Figure 2 (Sheet 1)

B. Remove fasteners designated in Detail I.

NOTE: If hole has a bushing remove the bushing prior to eddy current inspection.

C. Clean loose dirt and paint from inside and around fastener hole.

D. Remove build-up of paint, sealant, etc. from around outside of hole where probe collar will bear.

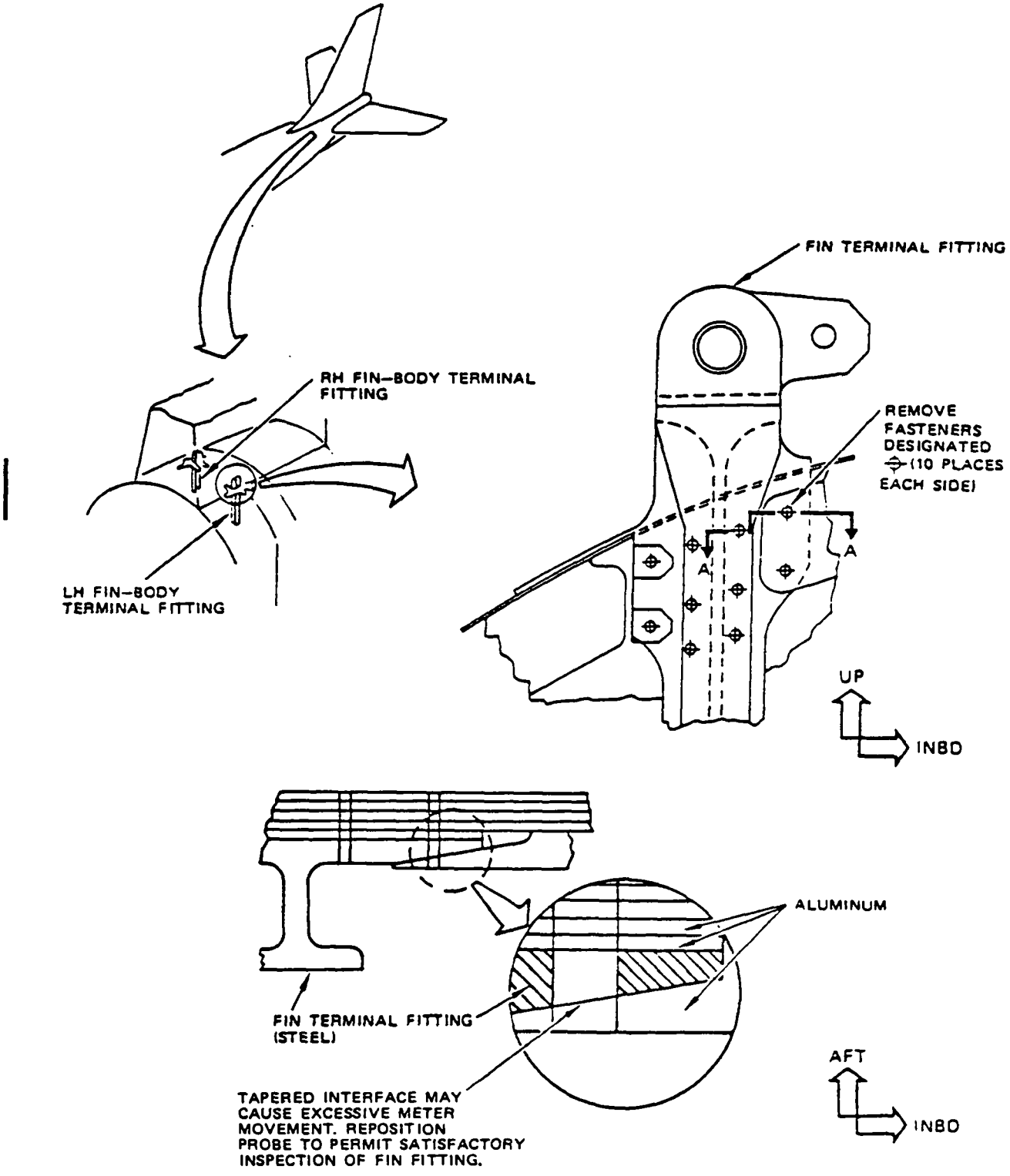
NOTE: If surface of hole is sufficiently rough to cause erratic eddy current responses, a hole clean up ream should be accomplished.

5. Inspection Procedure

A. Refer to Part 6, 51-00-00, Fig. 2, Fastener Holes in Steel Parts. Inspect fin terminal fitting holes identified in Detail I.

NOTE: Tapered flange of terminal fitting may cause interference, see Detail I, Section A-A.

Aft Fin Terminal Fitting Attachment Holes, BS 1505.87
Figure 2 (Sheet 2)



SECTION A–A

AFT FIN–BODY TERMINAL FITTING
DETAIL 1

Aft Fin Terminal Fitting Attachment Holes, BS 1505.87
Figure 2 (Sheet 3)